Work Order II October 13, 2011 10:			*748	75*						Page 1
Item ID: D349 Revision ID: Item Name: Cross	90-1 Bolt Spacer		Accept	*N900	040	100	* s	etup Star Stop	i Vi	S1* S2*
Start Date: 10/13 Required Date: 10/27 Reference:	3/11 Start Qty: 60.00	*60* *60*		Cust Item I Customer:	D:					
Approvals: Pro	cess Plan: M. L. J	Date: 11 10	14 Tooling:	Da	ite:	-	R	un Star	I <i>/</i> J	R1*
	•	Date:		Da	ıte:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3490	Rev A		•							
*100 *100 Hardinge Hardinge CNC Lathe Smal	FOLIO RE DWG REV	S PER FOLIO FA628 &	0.00 0.00 DWG D3490 U / し) よ	-1		9	64	J		
*110 * QC Quality Control	QC2- Inspect parts off Memo		0.00 S \ 1.00 \	21			64			
120 *120* QC Quality Control	QC8- Inspect parts - se	cond check	0.00	11.10.	23		Et	d'	· -	- · · · · · · · · · · · · · · · · · · ·

Dart Aerospac	e Ltd
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W/O:			V	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C C	losed:		Date: _	· 6
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Initial Action Description		n B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
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ı								•	
	1	1	1		1	1		I	1

Nork Order ID	-							<u> </u>	·		
Revision ID:		*		*748	375*			,			Page 2
Required Date: 10/27/11 Req'd Qty: 60.00 *60* Customer:	Revision ID:		acer	Accept	*N900	<u>04010</u>	0* s	Setup		1 74 4	
Approvals: Process Plan: Date: Tooling: Date: Stop VC: Date: SPC (Y/N): Date: Stop VR 7* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *130* *130*	Required Date:		- •			D:			.		
Work Center ID Description Identify as per dwg & Stock Location: Run Hours 0.00 Code Qty Qty Number Stamp 0.00 #130*	Approvals:		an:				- -	Run		*N *N	R1* R2*
Packaging ***STOCK IN SKIDTUBE CELL***	Work Center II 130 *130* Packaging	D	Description Identify as per dwg & Sto	Run Hours 0.00	Tool ID		_		•		

140

QC21- Final Inspection - Work Order Release

0.00

*14**0***

Quality Control

Memo

0.00

M/10/3198

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W/O:			WO	RK ORDER CHANGE	S				<u>E</u>
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				· · · · · · · · · · · · · · · · · · ·					
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A :	Date: _	·
	R	esolution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	1)			
		Description of NC	Corrective Action		Section B		ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	QC Inspector
		-		J					

Picklist Print

October 13, 2011 10:39:43 AM

74875 Work Order ID: 74875

Parent Item: D3490-1

D3490-1 Parent Item Name: Cross Bolt Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Page 1

Start Qty: 60.00 Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Primary Qty on Component Item ID/ Replacement Mfg/ Bin Last Route Unit of Qty per Kit Total Qty Date Status Seq ID Measure Hand Issued Item Name Item Location Location Qty Issued Item ID Purch M6061T6T0.500W.049 No 100 f 284.8565 0.266 Purchased **

M6061T6T0 500W 049

6061-T6 RD Tube .500 x.049W

Loc Code Loc Qty Location MAT014 284.856481 284.856481

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W/O:			WO	RK ORDER CHANG	ES		-						
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				•									
		-											
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date: _					
	Res	solution:	Disposition):	_ QA: N/C (closed:		Date: _					
NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	OTED	Description of NC			ion B	Verifi	cation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	74875
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
Ø0.500	+0.006/-0.001	-507			31-9		
0.049	+/-0.010	.049		-			
Ø0.402	+0.006/-0.001	0,405				····	
3.085	+0.030/-0.000	3.105		_			
0.050 x 45°	+/-0.010	20502499					
	•						
_				7			
							
					-		
· · · · · · · · · · · · · · · · · · ·							
easured by:	L	Audited by:	29		Prototype App	oroval:	N/A

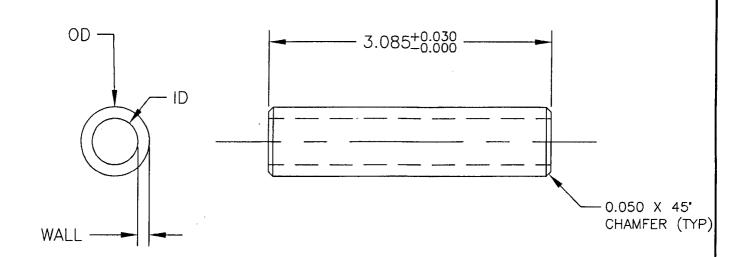
Measured by:	SA.	Audited by: 2	Prototype Approval:	N/A
Date:	11/0/21	Date: 11. 10 23	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	Α	06.10.06	New Issue	KJ/JLM	
-	В	08.06.02	Dimensions and tolerances revised	KJ/DD 14	
	С	08.10.07	0.050 x 45° dimension revised	KJ/DD	N/

	•									
W/O:		**************************************	N	ORK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE			У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•			
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQ	A:	Date: _	
	Re	solution:	Disposit	ion:	QA: N	/C Clos	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC			ection B			cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Sect	ion C	Chief Eng	QC Inspector
				·						



DESIGN	PH	DRAWN BY	DART A	EROSPACE PORT HADLOCK, W	
CHECK	7.8	APPROVED M	DRAWING NO.	-	REV. A
	-111	-44-	D3490		SHEET 1 OF 1
DATE			TITLE		SCALE
06.0	1.04		CROSS BOLT	SPACER	NTS
A		06.01.04	NEW ISSUE		



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART	OD	WALL	ID	MATERIAL SPEC
NUMBER			(REF)	
D3490-1	0.500 乡 と	_0.049	0.402_	M6061T6T0.500W.049-
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 74872

11/10/14

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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50	:		,					1		
Part No: PAR #:		Fault Categ	Fault Category: No			NCR: Yes No DQA:				
Resolution:			Disposition	Disposition: QA			A: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR)				
DATE	OTED	Description of NC Section A		ion B	Verific	Verification	Approval	Approval QC inspector		
	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C			
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